

Date: Wednesday, 1/11/2006 4:29:32 PM  
 User: Kim Johnston

## Process Sheet

|  |  |
|--|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services    | <b>Drawing Name</b> : CONSOLE SIDE LH (206 HI-SLOPE)       |
| <b>Job Number</b> : 25472                                |  |
| <b>Estimate Number</b> : 11001                           |  |
| <b>P.O. Number</b> : N/A                                 | <b>Part Number</b> : D26022                                |
| <b>This Issue</b> : 1/11/2006 <b>S.O. No.</b> : N/A      | <b>Drawing Number</b> : D2602 REV A1                       |
| <b>Prsht Rev.</b> : NC                                   | <b>Project Number</b> : N/A                                |
| <b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS    | <b>Drawing Revision</b> : A1                               |
| <b>Previous Run</b> : 25141                              | <b>Material</b> : N/A                                      |
| <b>Written By</b> : SEE COMMENT BELOW                    | <b>Due Date</b> : 1/30/2006 <b>Qty:</b> 10 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : SEE ABOVE DATE & USEC |  |
| <b>Comment</b> : Est. E 04.02.25 Reformat KJ/RF          |  |
| Note: Issue with part number D2602-1                     |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M2024T3S040 | 2024-T3 .040 sheet |
|-----|-------------|--------------------|



**Comment:** Qty.: 1.4146 sf(s)/Unit Total : 14.1456 sf(s)  
 2024-T3 .040 sheet  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040) Batch H 19059

*ml 06/02/20 10*

|     |       |       |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



**Comment:** SHEAR  
 Cut Blank per template DT8243

*ml 06/02/20 10*

|     |       |                                |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA145 and Dwg D2602  
 Stack of 10  
 Identify as D2602-2

*ml 06/02/20 10*

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*ml 06/02/20 10*

|     |     |              |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



**Comment:** SECOND CHECK

*Ep 06/02/20 10*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 06/02/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 1/11/2006 4:29:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 25472

Part Number: D26022

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |          |          |
|-----|----------|----------|
| 6.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

DL 06/02/22

10

SB 06/02/24

10

|     |     |                              |
|-----|-----|------------------------------|
| 7.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

|     |                 |                            |
|-----|-----------------|----------------------------|
| 8.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/02/26

10

|     |     |   |
|-----|-----|---|
| 9.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

|      |             |                       |
|------|-------------|-----------------------|
| 10.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

use for 25446 u/o ml 06/02/27

10

|      |    |                  |
|------|----|------------------|
| 11.0 | DC | DOCUMENT CONTROL |
|------|----|------------------|



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/02/27

Job Completion



u 06.02.27

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

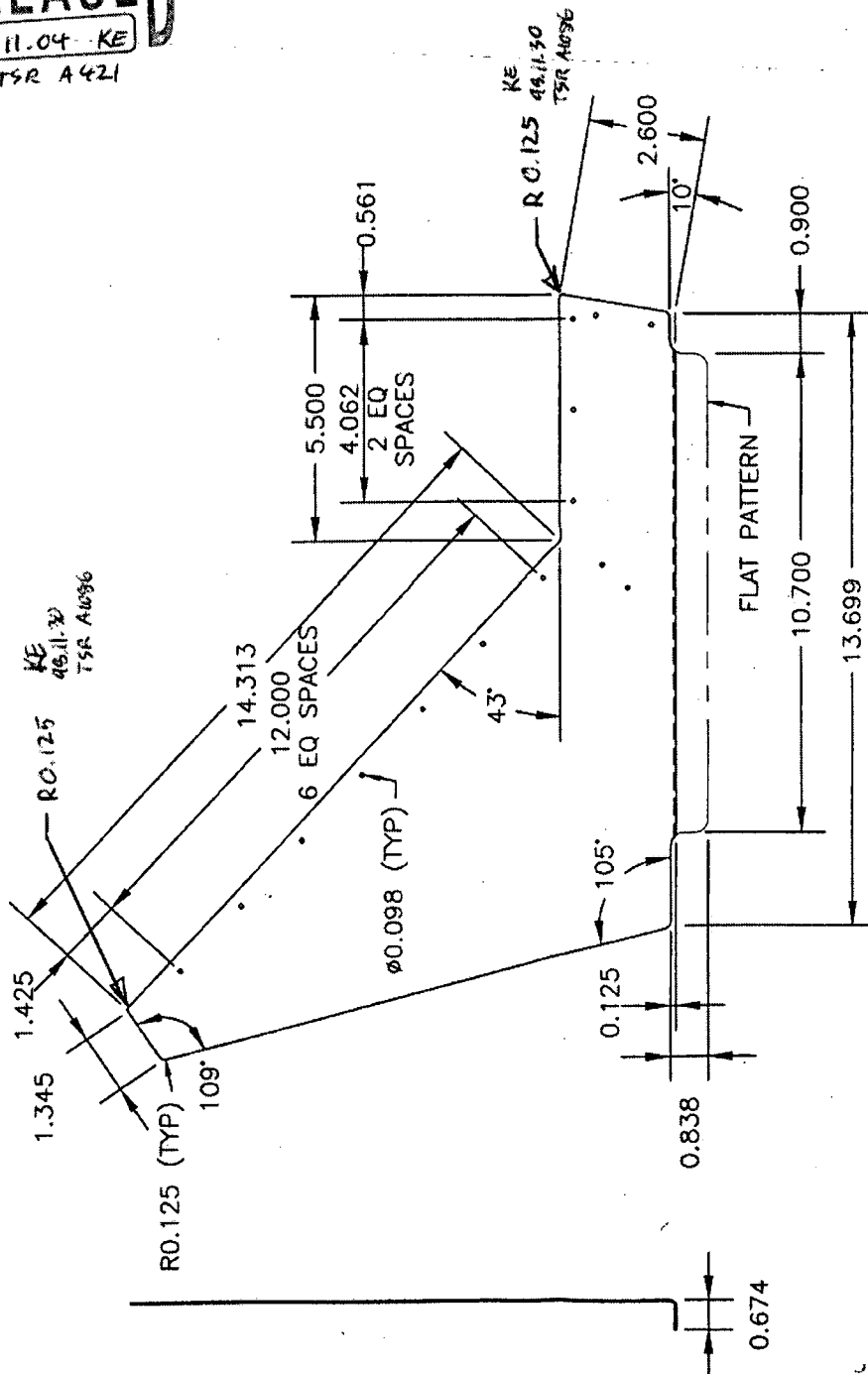
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



|                     |                       |  |                        |
|---------------------|-----------------------|--|------------------------|
| DESIGN<br><i>JS</i> | DRAWN BY<br>BW        | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |                        |
| CHECKED<br>KE       | APPROVED<br><i>JS</i> | DRAWING NO.<br>D2602   | REV. A<br>SHEET 1 OF 1 |
| DATE<br>97.10.22    | TITLE<br>CONSOLE SIDE |  | SCALE<br>1:4           |
| A                   | 97.10.22              | D2602 WAS D206-547-21/ -22                                   |                        |
| AI                  | <i>gr</i> 02.06.04    | ADD FINISH   |                        |

RELEASED  
97.11.04 KE  
TSR A421



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK  
PROFILE CONTROLLED BY FOLIO H2602  
BEND RADIUS 0.093  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 4-1  
D2602-1 SHOWN  
D2602-2 OPPOSITE

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

